

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016358**Date Inspected:** 16-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Qiu Wen	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	Tower	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no.10

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 057180 perform FCAW welding on; Lift 13 Component, Bike path and the weld joint is identified as BK 004A7 -030-047.

ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2131.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040521 perform SMAW welding on; South shaft, Lift 4, Mounting plate on Skin B and the weld joint is identified as CAMPSA4-14,15,16. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2113 and WPS-B-P-2112. (Photo attached)

Bay no. 11

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040655 perform SMAW Repair welding on; Lift 13 Component, Bike path and the weld joint is identified as BK 004A1 -024-009. ZPMC CWI Identified as Mr. Yu DongPing. The welding parameters as measured using QC's

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calibrated instruments appeared to be in general compliance with WPS-345- SMAW- 1G (1F) -Repair. The Welding repair report (WRR) found to be WRR-B-WR 14529.

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 070006 perform SMAW welding on; West shaft, Lift 5, Intersection diaphragm plate to Skin E (Outside) and the weld joint is identified as WSD1-TL5-4B/F-07. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U4c. (Photo attached)

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066443 perform SMAW welding on; West shaft, Lift 5, Intersection diaphragm plate to Grillage plate and the weld joint is identified as WSD1-TL5-4B/F-14B. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U5b.

6. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046709 perform SMAW welding on; East shaft, Lift 5, Intersection diaphragm plate to Grillage plate and the weld joint is identified as ESD1-TL5-2B/F-10. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U4c.

Blast shop 1

7. This QA inspector, Baskar Govindarajan, performed Pre blast inspection of external surfaces of East tower, Lift 2. All the areas marked which requires grinding, weld repair, Grinding & MT wherever applicable in all the Skins of Tower from 50.3 to 83 mtr. Elevation. This inspection was carried out along with QA Inspector Mr. Sandeep Kumar whose lot no. is B 227, Mr. Bera (B 205), Mr. Sugunthan (B 248), Mr. Gade (B 307) and Mr. Art Peterson . All the marked points shown to ZPMC inspector Mr. Zhao Chen Sun and ABF Inspector Mr. Chen. All the weld repair areas (13 nos) marked in weld map in detail and the same was signed by ZPMC and ABF Inspector. Mr. James Lumley, QA NACE Level III Inspector was present during the inspection process. (Photos attached)

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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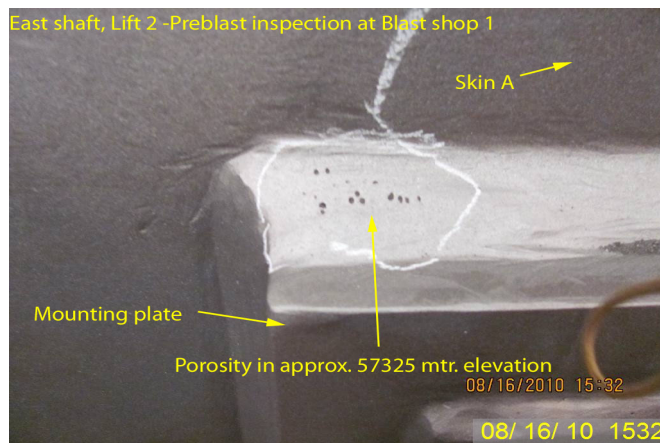
West shaft, Lift 5 - Skin E to Intersection diaphragm welding -Bay 11



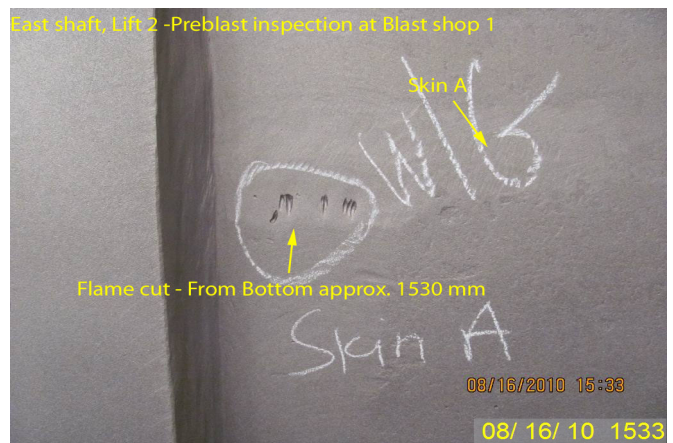
South shaft, Lift 4 - Skin B mounting plate welding at Bay no. 10



East shaft, Lift 2 -Preblast inspection at Blast shop 1



East shaft, Lift 2 -Preblast inspection at Blast shop 1



Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer